

Date: Tuesday, 22/04/2008 3:53:11 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SADDLE, OUTBOARD, LH, 206		
Job Number	: 38749			Part Number	: D26651		
Estimate Number	: 10818			Drawing Number	: D2665 REV.D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 22/04/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 10/05/2008 Qty: 12 Um: Each		
Previous Run	: 37549						
Written By	:						
Checked & Approved By	: <u>JUL 08.4.23</u>						
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	Saddle Billet, 7075	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number: 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 5- Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2665-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/06/20 QA: N/C Closed: _____ Date: _____

NCR: 38749		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.06.20	2	CHAMFER ON SKID HOLES. TOO DEEP: $1/8'' \times 45^\circ$ INSTEAD OF $0.050 \times 45^\circ$ ALONG ONE EDGE (TOP) QTY(1) AFFECTED	GP 08.06.20 P/C QSI 042	PART ACCEPTABLE. NOT IN AREA OF MIN THICKNESS.	J.F. 08/06/20 S 08/06/23	S 08/06/20 P/C QSI 042	08.06.20 P/C QSI 042	S 08/06/23
08.06.20	2	CHAMFER ON SKID HOLES IS. TOO DEEP: $0.100 \times 45^\circ$ INSTEAD OF $0.050 \times 45^\circ$ ALONG ALL EDGES QTY(1) AFFECTED	GP 08.06.20 P/C QSI 042	PART ACCEPTABLE. NOT IN AREA OF MIN THICKNESS.	J.F. 08/06/20 S 08/06/23	S 08/06/20 P/C QSI 042	08.06.20 P/C QSI 042	S 08/06/23
		PC. operator error PL. operator error						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 38749

Part Number: D26651

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Amk 08/06/22

(12)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

2/1/12 08/06/23

(12)

7.0	POWDER COATING	POWDER COATING
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POWDER COATING

m107925



(12) PTO

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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INSPECT POWDER COAT/CHEMICAL CONVERSION



(12X)

Comment: INSPECT POWDER COAT

m-1

08/06/24

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST436

2/1/12

(12)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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FINAL INSPECTION/W/O RELEASE



08/06/25 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



c 208/06/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/23	7.0	Start time: 10:35 Temp: 320° Finish time: 11:05		JL	07/06/23	12.		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38749
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					By	Date
				1	2	3	4			
A	0.100	0.140		1.19"	1.18"	1.18"	0.117			
B	0.100	0.140		1.17"	1.18"	1.18"	0.117			
C	1.125	1.145		1.132"	1.135"	1.135"	1.136"			
D	0.615	0.685		.650"	.650"	.650"	0.650			
E	0.240	0.260		.250"	.249"	.249"	0.245			
F	1.313	1.343		1.323"	1.323"	1.323"	1.321			
G	0.210	0.230		.218"	.218"	.218"	0.218			
H	0.100	0.180		.120"	.130"	.130"	0.135			
I	2.470	2.510		2.500"	2.502"	2.502"	2.501			
J	1.565	1.585		1.569"	1.574"	1.574"	1.575			
K	0.235	0.240		.240"	.240"	.240"	0.238			
L	0.100	0.120		.110"	.110"	.110"	0.110			
M	0.990	1.010		1.000"	.997"	.997"	1.000			
N	0.510	0.515		.510"	.510"	.510"	0.511			
O	5.990	6.010		6.003"	6.000"	6.000"	6.000			
P	1.245	1.255		1.249"	1.250"	1.249"	1.250			
Q	2.495	2.505		2.500"	2.500"	2.500"	2.500			
R	0.313	0.318		.313"	.313"	.313"	0.315			
S	0.315	0.322		.321"	.321"	.321"	0.322			
T	2.495	2.505		2.499"	2.499"	2.499"	2.500			
U	1.357	1.367		1.364"	1.364"	1.364"	1.362			
V	0.787	0.807		.797"	.797"	.797"	0.795			
W	0.540	0.560		.551"	.548"	.548"	0.546			
X	1.674	1.684		1.681"	1.681"	1.681"	1.679			
Y	0.257	0.262		.259"	.259"	.259"	0.260			
Z	0.912	0.932		.923"	.923"	.923"	0.920			
AA	0.490	0.510		.504"	.501"	.501"	0.497			
AB	0.178	0.198		R.187"	R.183"	R.183"	R.188"			
AC										
AD										
AE										
AF										
Accept/Reject										

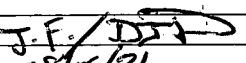
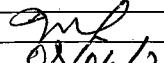
Measured by:	J.F. /DTI	Audited by:	SMR
Date:	08/06/21	Date:	08/06/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim: U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	SP

DART AEROSPACE LTD	Work Order:	38749
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.100	0.140		0.1185	0.1185	0.118	0.118		
B	0.100	0.140		0.1195	0.121	0.1185	0.120		
C	1.125	1.145		1.136	1.136	1.135	1.135		
D	0.615	0.685		0.649	0.649	0.649	0.650		
E	0.240	0.260		0.246	0.246	0.246	0.248		
F	1.313	1.343		1.322	1.322	1.321	1.3205		
G	0.210	0.230		0.219	0.219	0.219	0.219		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.501	2.501	2.500	2.501		
J	1.565	1.585		1.575	1.575	1.574	1.575		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.999	0.999	0.999	0.999		
N	0.510	0.515		0.511	0.511	0.511	0.511		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.248	1.249	1.249	1.250		
Q	2.495	2.505		2.499	2.500	2.500	2.499		
R	0.313	0.318		0.3155	0.3155	0.3155	0.316		
S	0.315	0.322		0.322	0.322	0.322	0.322		
T	2.495	2.505		2.498	2.499	2.500	2.4985		
U	1.357	1.367		1.361	1.362	1.362	1.363		
V	0.787	0.807		0.795	0.795	0.795	0.797		
W	0.540	0.560		0.545	0.545	0.545	0.544		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.920	0.920	0.920	0.920		
AA	0.490	0.510		0.491	0.499	0.493	0.498		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F. / 	Audited by:	
Date:	08/06/21	Date:	08/06/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM 	

DART AEROSPACE LTD	Work Order:	38749
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11 8	12		
A	0.100	0.140		0.119	0.119	0.120	0.120		
B	0.100	0.140		0.1185	0.120	0.119	0.117		
C	1.125	1.145		1.1365	1.1355	1.134	1.138		
D	0.615	0.685		0.650	0.650	0.650	0.650		
E	0.240	0.260		0.247	0.2460	0.2460	0.245		
F	1.313	1.343		1.321	1.320	1.320	1.320		
G	0.210	0.230		0.219	0.219	0.220	0.220		
H	0.100	0.180		0.135	0.135	0.140	0.140		
I	2.470	2.510		2.501	2.500	2.501	2.501		
J	1.565	1.585		1.5745	1.573	1.571	1.577		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.110	0.110	0.116	0.110		
M	0.990	1.010		0.999	0.999	0.999	0.999		
N	0.510	0.515		0.511	0.511	0.511	0.511		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.249	1.249	1.250	1.249		
Q	2.495	2.505		2.498	2.4985	2.4985	2.499		
R	0.313	0.318		0.316	0.316	0.316	0.316		
S	0.315	0.322		0.322	0.322	0.322	0.322		
T	2.495	2.505		2.500	2.4985	2.499	2.499		
U	1.357	1.367		1.362	1.361	1.362	1.362		
V	0.787	0.807		0.794	0.795	0.794	0.796		
W	0.540	0.560		0.545	0.545	0.545	0.545		
X	1.674	1.684		1.679	1.679	1.678	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.922	0.922	0.921	0.921		
AA	0.490	0.510		0.505	0.501	0.501	0.504		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									

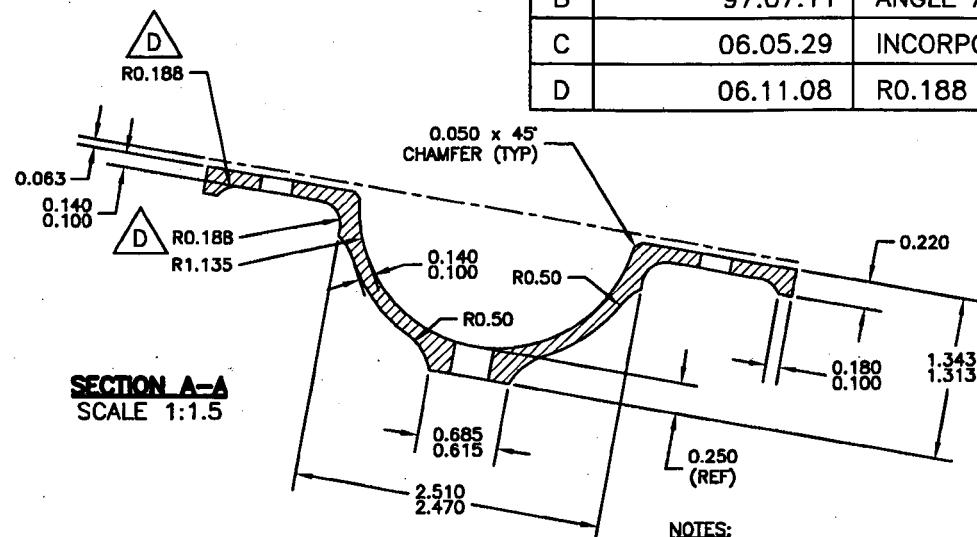
Accept/Reject

Measured by:	DSP	Audited by:	Onk
Date:	08/06/22	Date:	08/06/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>CB</i>	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3	
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



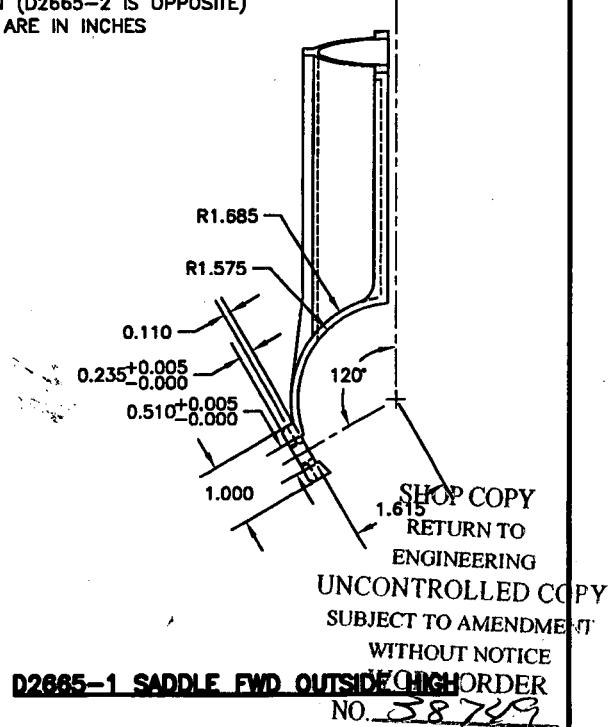
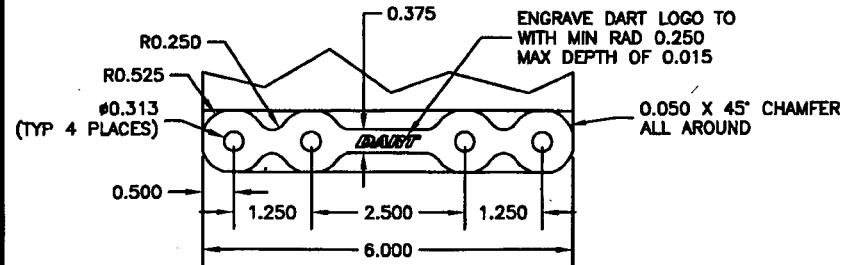
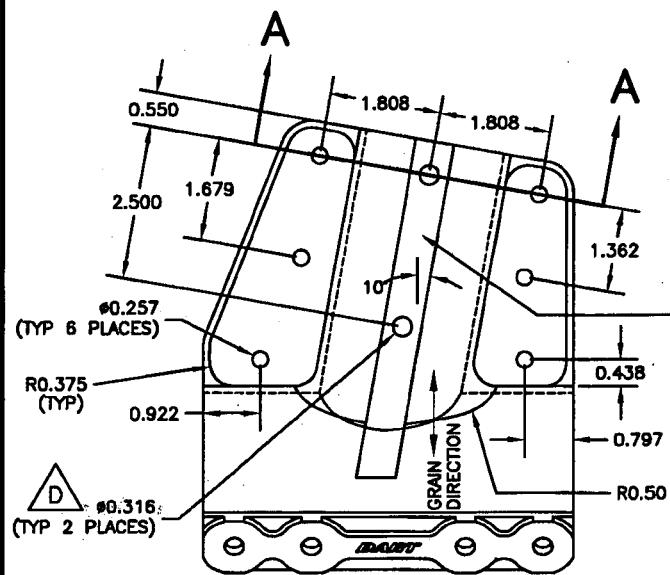
RELEASED

07.02.12

SECTION A-A
SCALE 1:1.5

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2665-1 SADDLE FWD OUTSIDE HIGH
NO. 38749

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